

# Work Order ID 119994

\*119994\*

Wednesday, June 11, 2014 1:48:13 PM

Page 1

Item ID: D206-642-218 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH, High Gear, Thru-Bolt with Run-on Landing Wearplates (2.0" Bolt Spacing on Aft Saddle)  
 Start Date: 6/2/2014 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 6/6/2014 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: PER NCR

Approvals: Process Plan: MWF Date: 14-6-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								

150

0.00

\*150\*

HandFinish  
Hand Finishing

Memo

0.00

PULL FROM STOCK D206-642-218 X B108917

REWORK PER ATT EMAIL  
D2651-3 X 8 B 113577

RTV 06/15 M 115 792

PLM 14 06 19

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC  
Quality Control

Memo

0.00

SNB 14/6/13

170

0.00

\*170\*

Packaging  
Packaging

Memo

0.00

ENSURE ORIGINAL KIT IS IN BOX

JUN 23 2014

DAS  
06  
9-00

2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____

# Work Order ID 119994

Wednesday, June 11, 2014 1:48:13 PM

**\*119994\***

Page 2

Item ID: D206-642-218 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Required Date: 6/6/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: PER NCR

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
190 <b>*190*</b> Packaging Packaging	Memo REPACKAGE USING ORIGINAL B/N	0.00 0.00							
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

SMP  
14/10/23

F6004

JUN 23 2014

DAS  
06  
9-23

MCS 1406 23

MF  
14-6-23

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Work Order update only ☐

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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Wednesday, June 11, 2014 1:48:12 PM

**\*1 19994\***

**\*D206-642-218\***

**Required Date:** 6/6/2014

**Required Qty: 1.00**

**Comments:** IPP REV:A 11.11.17 PER IIN REVO DD VERF;EC IPP Rev:B  
12.11.21 ECN12-679 DD verf:JLM IPP Rev:C 14.04.25  
ECN14-520 DD verf:JLM

**\*D2651-3\***

### O-Ring

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	546	
104725	8	
112214	44	
113577	494	

8

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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## Melanie Fauteux

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**From:** Linda Lacelle  
**Sent:** Thursday, May 29, 2014 1:31 PM  
**To:** Patrick Smith; Mike Petsche  
**Cc:** Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd; Melanie Fauteux  
**Subject:** RE: 350 skids and 206 skids

Thx...when can all of these be done? Also, are the 205 also affected ?  
LL

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**From:** Patrick Smith  
**Sent:** May-29-14 1:29 PM  
**To:** Linda Lacelle; Mike Petsche  
**Cc:** Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd  
**Subject:** RE: 350 skids and 206 skids

Linda,

I spoke with David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

The existing Plugs would require:

- 1) Removal from the Skidtube
- 2) Removal of the current O-Ring
- 3) Cleaning with Alcohol
- 4) Installation of NEW O-Ring
- 5) Generous coating of the RTV
- 6) Insertion of plug into the Spacer
- 7) Clean up of exterior of Skidtube.

Pat

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**From:** Linda Lacelle  
**Sent:** May-29-14 10:21 AM  
**To:** Mike Petsche  
**Cc:** Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod  
**Subject:** 350 skids and 206 skids  
**Importance:** High

I heard yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution found to fix this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

Thx

Linda

## List Lots

Page 1 of 1

Monday, June 02, 2014 9:21:01 AM

Criteria : Item ID: D206-642-218 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D206-642-218	Main Warehouse	108917	12/23/2013	1.0000	QC21	CHG002	
Skidtube RH, High Thru-	FG082						
Bolt Run-On Landing 2.0"							
Bolt Spacing On Aft Saddle							
Total:				1.0000			

\* 119994

D20651-1/3 x8



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



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